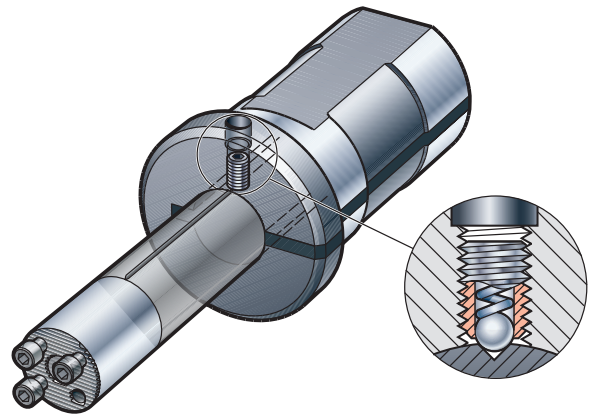


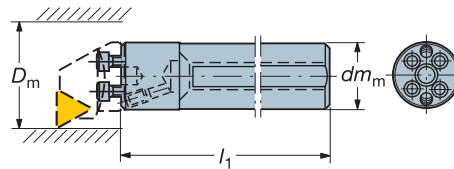
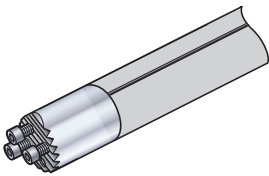
CoroTurn® SL boring bars

Carbide reinforced boring bars with SL (570) coupling for overhang up to 6 x bar diameter. All with internal cooling supply and groove for EasyFix mounting. EasyFix sleeves – the fast and simple way to achieve the correct centre height of the cutting edge.

These new bars increase the length to diameter ratio that can be machined without the need for a dampening system. All types of CoroTurn/CoroCut/Q-Cut SL (570) heads can be used on these new bars. An invaluable tool in internal turning, grooving and threading operations.



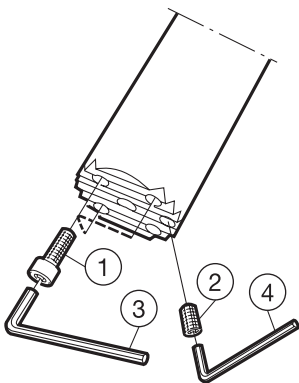
570-2C



All with internal coolant supply
Max recommended overhang 6 x dm_m

Ordering code	Dimensions, mm		
	dm_m	D_m min	l_1
570-2C 16 170 CR	16	20	170
570-2C 20 200 CR	20	25	200
570-2C 25 250 CR	25	32	250

Ordering example: 2 pieces 570-2C 16 170 CR



	1	2	3	4
Shank holders	Screw	Coolant stop	Key (mm)	Key
570-2C 16 170 CR	3212 030-301	3214 010-203	265.2-818 (2.38)	3021 012-015 (1.5)
570-2C 20 200 CR	3212 030-351	3214 010-203	3021 011-764 (2.78)	3021 012-015 (1.5)
570-2C 25 250 CR	3212 010-258	3214 010-255	5680 010-05 (3.0)	174.1-870 (1.98)

= New item

For a complete product assortment and further technical information, see Main Catalogue 2006 and Metalcutting Technical guide.

Cutting speed recommendations

The recommendations are valid for use with cutting fluid.

ISO	CMC No.	Material	Specific cutting force k_c 0.4 N/mm ²	Hardness Brinell HB	<<<< WEAR RESISTANCE			
					CT5005	CT5015	GC1525	
					h_{ex} , mm = feed f_n , mm/r at κr 90°-95°			
					Cutting speed (V_c), m/min			
P	01.1	Unalloyed steel C = 0.1-0.25%	2000	125	730-590-440	650-540-440	560-465-380	
	01.2	C = 0.25-0.55%	2100	150	650-530-420	570-480-385	495-415-335	
	01.3	C = 0.55-0.80%	2200	170	-	510-425-340	430-365-295	
	Steel	Low-alloy steel (alloying elements ≤5%)						
		02.1	Non-hardened	2150	180	530-450-360	480-400-320	375-320-255
		02.12	Ball bearing steel	2300	210	-	-	-
		02.2	Hardened and tempered	2550	275	395-325-250	285-235-190	200-165-135
		02.2	Hardened and tempered	2850	350	320-260-200	230-190-150	160-135-110
		High-alloy steel (alloying elements >5%)						
		03.11	Annealed	2500	200	-	395-330-250	260-215-175
		03.21	Hardened tool steel	3900	325	-	195-165-130	145-115-90
		Steel castings						
		06.1	Unalloyed	2000	180	-	260-215-175	225-185-145
06.2	Low-alloy (alloying elements ≤5%)	2100	200	-	270-225-170	175-145-105		
06.3	High-alloy (alloying elements >5%)	2650	225	-	200-165-125	140-115-85		
ISO	CMC No.	Material	Specific cutting force k_c 0.4 N/mm ²	Hardness Brinell HB	<<<< WEAR RESISTANCE			
					GC1525	GC1005	GC1105	
					h_{ex} , mm = feed f_n , mm/r at κr 90°-95°			
					Cutting speed (V_c), m/min			
M	05.11	Ferritic/martensitic Bars/forged Non-hardened	2300	200	290-240	380-305-245	380-305-245	
	05.12	PH-hardened	3550	330	170-150	350-280-225	350-280-225	
	05.13	Hardened	2850	330	170-150	245-195-160	245-195-160	
	Austenitic Bars/forged							
	05.21	Austenitic	2300	180	220-195	410-330-265	410-330-265	
	05.22	PH-hardened	3550	330	195-170	220-175-145	220-175-145	
	05.23	Super austenitic	2950	200	145-130	245-200-160	245-200-160	
	Austenitic-ferritic (Duplex) Bars/forged							
	05.51	Non-weldable ≥ 0.05%C	2550	230	-	315-255-205	315-255-205	
	05.52	Weldable < 0.05%C	3050	260	-	280-225-185	280-225-185	
	Ferritic/martensitic Cast							
	15.11	Non-hardened	2100	200	-	-	-	
	15.12	PH-hardened	3150	330	-	-	-	
15.13	Hardened	2650	330	-	-	-		
Austenitic Cast								
15.21	Austenitic	2200	180	-	-	-		
15.22	PH-hardened	3150	330	-	-	-		
15.23	Super austenitic	2700	200	-	-	-		
Austenitic-ferritic (Duplex) Cast								
15.51	Non-weldable ≥ 0.05%C	2250	230	-	-	-		
15.52	Weldable < 0.05%C	2750	260	-	-	-		
ISO	CMC No.	Material	Specific cutting force k_c 0.4 N/mm ²	Hardness Brinell HB	<<<< WEAR RESISTANCE			
					CB7050/CB50	CC6090	GC1690	
					h_{ex} , mm = feed f_n , mm/r at κr 90°-95°			
					Cutting speed (V_c), m/min			
K	Malleable cast iron							
	07.1	Ferritic (short chipping)	940	130	-	740-600-500	740-600-500	
	07.2	Pearlitic (long chipping)	1100	230	-	640-500-400	640-500-400	
	Grey cast iron							
	08.1	Low tensile strength	1100	180	1700-1450-1200	740-600-500	740-600-500	
	08.2	High tensile strength	1150	220	1450-1250-1050	690-540-435	690-540-435	
	Nodular SG iron							
	09.1	Ferritic	1050	160	-	-	580-450-345	
	09.2	Pearlitic	1750	250	-	-	480-350-250	
09.3	Martensitic	2700	380	-	-	325-260-220		

Cutting speed recommendations

TOUGHNESS >>>>								
GC1025	GC4005	GC4015	GC4225	GC4025	GC2015	GC4035	GC2025	GC235
0.1-0.3-0.5	0.1-0.4-0.8	0.1-0.4-0.8	0.1-0.4-0.8	0.1-0.4-0.8	0.1-0.4-0.8	0.1-0.4-0.8	0.1-0.4-0.8	0.1-0.4-0.8
310-255-195 280-225-180 260-210-170	590-430-315 530-385-280 510-365-265	540-390-285 485-350-255 460-330-240	510-345-245 455-305-215 425-290-205	485-330-230 430-290-205 405-275-195	440-300-210 390-265-185 370-250-175	405-260-190 365-235-170 345-220-160	295-200-145 265-180-130 250-170-120	185-135-95 165-120-85 155-115-80
- - - -	580-390-270 510-335-235 315-220-165 250-175-135	530-355-245 460-305-215 285-200-150 230-160-120	460-305-215 395-265-190 270-190-145 215-150-120	435-290-205 380-255-180 255-180-140 205-145-115	395-265-185 345-230-160 255-180-140 205-145-115	285-175-130 250-155-110 175-115-80 140-90-65	220-145-100 195-125-85 145-95-65 115-75-50	155-110-70 - 110-70-50 85-55-39
- -	425-280-205 210-135-100	385-255-190 190-120-90	300-205-150 135-95-75	285-195-145 130-90-70	260-180-130 115-85-65	225-145-100 105-65-45	185-125-85 85-55-338	145-100-65 65-45-30
- - -	320-225-175 275-195-150 210-145-110	285-205-160 250-175-135 195-130-100	240-180-130 210-140-100 185-125-90	230-170-125 200-135-95 175-120-85	210-255-110 180-120-85 160-110-75	175-130-95 155-95-65 135-90-65	140-105-80 125-80-55 110-75-50	100-80-60 95-65-45 80-60-39
TOUGHNESS >>>>								
GC1025	GC4225	GC4025	GC2015	GC4035	GC2025	GC2035	GC235	
0.1-0.2-0.3	0.2-0.4-0.6	0.2-0.4-0.6	0.2-0.4-0.6	0.2-0.4-0.6	0.2-0.4-0.6	0.2-0.4-0.6	0.2-0.4-0.6	
280-215-170 155-125-100 165-135-120	280-235-210 130-105-80 160-130-95	265-225-200 125-100-75 150-125-90	240-205-185 115-90-70 135-115-80	225-190-170 85-65-50 100-70-50	210-175-135 100-70-50 110-80-55	180-160-130 85-65-45 95-70-50	130-110-90 70-55-45 75-60-50	
265-220-170 155-125-100 185-160-130	295-235-200 130-100-85 180-160-115	280-225-190 125-95-80 170-150-110	255-205-175 115-90-75 155-135-100	195-155-120 95-70-55 130-105-80	200-160-120 100-70-55 120-100-75	170-145-115 85-65-45 100-90-70	115-100-85 70-55-45 85-70-60	
210-170-130 190-140-110	250-215-170 210-175-135	240-205-160 200-165-130	220-185-145 180-150-120	180-140-110 130-115-105	190-150-110 150-120-90	160-135-105 130-110-85	105-95-80 95-80-70	
265-220-170 135-110-80 145-120-90	270-225-185 110-80-65 120-100-70	255-215-175 105-75-60 115-95-65	230-195-160 95-70-55 105-85-60	195-160-150 75-55-40 85-60-45	200-160-120 80-55-40 90-60-45	170-145-115 70-50-40 75-60-50	115-100-85 60-45-35 65-50-40	
235-180-150 135-110-80 175-150-125	230-190-155 110-80-65 170-130-110	220-180-150 105-75-60 160-125-105	200-165-135 95-70-55 145-115-95	155-120-95 75-55-40 115-90-70	175-135-100 80-55-40 120-90-65	150-120-95 70-50-40 100-80-60	100-90-75 65-45-33 80-65-55	
190-140-100 170-130-90	215-175-150 185-165-120	205-165-145 175-155-115	185-150-135 160-140-105	165-125-100 115-100-95	150-120-90 125-105-80	130-110-85 105-95-75	95-80-70 90-75-65	
TOUGHNESS >>>>								
CT5005	CT5015	GC3205	GC3210	GC4005	GC4015	GC3215	H13A	
0.1-0.2-0.3	0.1-0.2-0.3	0.2-0.4-0.6	0.2-0.4-0.6	0.2-0.4-0.6	0.2-0.4-0.6	0.2-0.4-0.6	0.1-0.3-0.5	
- -	200-165-135 140-115-95	460-380-325 375-310-265	385-315-265 315-255-215	345-285-235 280-230-190	310-255-215 250-210-175	260-215-185 210-175-150	140-125-110 125-110-90	
- -	320-260-220 280-235-205	530-435-375 425-350-300	445-360-305 355-290-245	380-320-275 305-260-230	350-295-250 270-235-210	300-250-210 240-200-170	180-145-110 140-115-95	
320-250-200 245-200-175 -	255-200-160 230-195-170 115-95-85	390-330-275 350-300-250 265-225-190	360-305-250 325-275-225 245-210-170	315-265-230 265-215-185 210-165-130	270-220-185 245-200-165 195-150-120	240-195-165 215-175-150 165-135-115	135-125-95 125-115-90 100-85-65	

Cutting speed recommendations

The recommendations are valid for use with cutting fluid.

ISO	CMC No.	Material	Specific cutting force k_c 0.4 N/mm ²	Hardness Brinell HB	<<<< WEAR RESISTANCE		
					CD10	CD1810	H10
					h_{ex} , mm \approx feed f_n , mm/r at κ_r 90°-95°		
					Cutting speed (V_c), m/min		
N	30.11	Aluminium alloys Wrought or wrought and coldworked, non-aging	500	60	2 000 (2500-250) ¹⁾		
					2 000 (2500-250) ¹⁾		
	30.12	Aluminium alloys Wrought or wrought and aged	800	100	2 000 (2500-250) ¹⁾		
					2 000 (2500-250) ¹⁾		
	30.21	Aluminium alloys Cast, non-aging	750	75	2 000 (2500-250) ¹⁾		
					2 000 (2500-250) ¹⁾		
	30.22	Aluminium alloys Cast or cast and aged	900	90	2 000 (2500-250) ¹⁾		
					2 000 (2500-250) ¹⁾		
	30.41	Aluminium alloys Cast, 13-15% Si	950	130	1 550 (1950-195) ¹⁾		
					770 (960-95) ¹⁾		
30.42	Aluminium alloys Cast, 16-22% Si	950	130	770 (960-95) ¹⁾			
				510 (640-65) ¹⁾			
33.1	Copper and copper alloys Free cutting alloys, $\geq 1\%$ Pb	700	110	500 (630-65) ¹⁾			
				500 (630-65) ¹⁾			
33.2	Copper and copper alloys Brass, leaded bronzes, $\leq 1\%$ Pb	700	90	500 (630-65) ¹⁾			
				500 (630-65) ¹⁾			
33.3	Copper and copper alloys Bronze and non-leadad copper incl. electrolytic copper	1750	100	300 (375-38) ¹⁾			
				300 (375-38) ¹⁾			
ISO	CMC No.	Material	Specific cutting force k_c 0.4 N/mm ²	Hardness Brinell HB	<<<< WEAR RESISTANCE		
					CC650	CC6080	CC670
					h_{ex} , mm \approx feed f_n , mm/r at κ_r 90°-95°		
					Cutting speed (V_c), m/min		
S	20.11	Heat resistant super alloys Iron base Annealed or solution treated	3000	200	-		
					-		
	20.12	Heat resistant super alloys Iron base Aged or solution treated and aged	3050	280	-		
					-		
	20.21	Heat resistant super alloys Nickel base Annealed or solution treated	3300	250	400-320		
					420-350-295		
	20.22	Heat resistant super alloys Nickel base Aged or solution treated and aged	3600	350	340-265		
					355-295-250		
	20.24	Heat resistant super alloys Nickel base Cast or cast and aged	3700	320	220-160		
					325-270-230		
	20.31	Heat resistant super alloys Cobalt base Annealed or solution treated	3300	200	345-260		
					-		
	20.32	Heat resistant super alloys Cobalt base Solution treated and aged	3700	300	300-225		
-							
20.33	Heat resistant super alloys Cobalt base Cast or cast and aged	3800	320	285-225			
				-			
23.1	Titanium alloys ²⁾ Commercial pure (99.5% Ti)	1550	Rm ³⁾ 400	H10			
				0.1-0.2-0.3			
				H10A			
				0.1-0.3-0.5			
23.21	Titanium alloys ²⁾ α , near α and $\alpha+\beta$ alloys, annealed $\alpha+\beta$ alloys in aged cond,	1700	950	H13A			
				0.1-0.3-0.5			
23.22	Titanium alloys ²⁾ β alloys, annealed or aged	1700	1050	H10			
				0.1-0.2-0.3			
					H10A		
					0.1-0.3-0.5		
					H13A		
					0.1-0.3-0.5		
					H10		
					0.1-0.2-0.3		
					H10A		
					0.1-0.3-0.5		
					H13A		
					0.1-0.3-0.5		
ISO	CMC No.	Material	Specific cutting force k_c 0.4 N/mm ²	Hardness	<<<< WEAR RESISTANCE		
					CB7015	CB7020/CB20	CB7050/CB50
					h_{ex} , mm \approx feed f_n , mm/r at κ_r 90°-95°		
					Cutting speed (V_c), m/min		
H	04.1	Hard steel Hardened and tempered	3250	45HRC	-		
					-		
					-		
	04.1	Hard steel Hardened and tempered	3950	50HRC	-		
					-		
					-		
	04.1	Hard steel Hardened and tempered	4700	55HRC	295-225-185		
					215-195-170		
					175-140-110		
	04.1	Extra hard steel Hardened and tempered	5550	60HRC	250-190-160		
185-165-145							
04.1	Extra hard steel Hardened and tempered	6450	65HRC	215-165-135			
				160-140-125			
10.1	Chilled cast iron Cast or cast and aged	2800	400 HB	-			
				-			
					180-150-120		

1) The cutting speeds, shown in the table, are valid for all feeds within the feed range.

2) 45-60° entering angle, positive cutting geometry and coolant should be used.

3) Rm = ultimate tensile strength measured in MPa.

Cutting speed recommendations

TOUGHNESS >>>>						
H13A						
0.15-0.8						
1 900 (2400-240) ¹⁾						
1 900 (2400-240) ¹⁾						
1 900 (2400-240) ¹⁾						
1 900 (2400-240) ¹⁾						
400 (500-50) ¹⁾ 250 (315-31) ¹⁾						
450 (560-55) ¹⁾ 450 (560-55) ¹⁾ 270 (340-34) ¹⁾						
TOUGHNESS >>>>						
S05F	GC1105	GC1005	H10A	H13A	GC1025	H10F
0.1-0.2-0.3	0.1-0.3-0.5	0.1-0.3-0.5	0.1-0.3-0.5	0.1-0.3-0.5	0.1-0.3-0.5	0.1-0.3-0.5
160-135-110 125-105-85	- -	150-100-70 120-80-60	85-70-55 65-55-40	80-65-50 60-50-40	75-60-45 55-45-35	70-55-40 50-40-30
100-85-70 90-75-60 80-65-55	90-55-30 80-50-27 70-45-24	90-55-30 80-50-27 70-45-24	55-40-32 40-32-21 26-21-16	50-40-30 40-30-20 25-20-15	45-35-25 35-25-15 23-17-12	40-30-20 30-20-10 20-15-10
100-85-70 90-75-60 80-65-55	90-60-30 80-50-27 70-45-24	90-60-30 80-50-27 70-45-24	55-40-32 40-32-21 26-21-16	50-40-30 40-30-20 25-20-15	45-35-25 35-25-15 23-17-12	40-30-20 30-20-10 20-15-10
H10F	GC1025					
0.1-0.3-0.5	0.1-0.3-0.5					
160-135-115 65-55-45 65-50-40	160-135-115 65-55-45 65-50-40					
TOUGHNESS >>>>						
CC6050	CC650	CC670	H13A	GC4005	GC3205	
0.05-0.15-0.25	0.1-0.25-0.4	0.1-0.25-0.4	0.1-0.3-0.6	0.1-0.3-0.6		
290-235-175 240-195-145 200-165-120	205-155-100 170-125-85 140-105-70	205-170-135 165-140-110 140-115-95	45-25-16 - -	65-45-28 - -	65-45-28 - -	
170-140-105 145-120-90	120-90-60 105-80-50	120-100-80 105-85-70	- -	- -	- -	
-	120-90-60	120-90-60	35-20-11	32-29-15	-	

Improved CoroCut® holders



CoroCut® 1- and 2-edge square shank holders

To provide a more secure fastening we have a new stronger clamping screw. This is for shank holders, size 20x20 (hxb) for insert seat sizes H and J. The new improved holders have an M at the end of the ordering code, e.g.

New Code
RF123H13-2020BM

Old Code
RF123H13-2020B

CoroCut® 3 Coromant Capto® cutting units and shank holders.

To facilitate easier and faster indexing of the insert in CoroCut 3 Coromant Capto and shank holders have been modified, making the insert clamping screw reachable from both sides of the holder. This is of particular benefit in sliding head and multi-spindle machines.

Note: The screws have Torx Plus size 15IP on top and size 8IP on the bottom. The key 5680 049-02, delivered with the holder comes in 15IP only. To adjust the bottom screw, screwdriver 5680 046-01 (size 8IP) should be ordered separately.

CoroCut® 1- and 2-edge

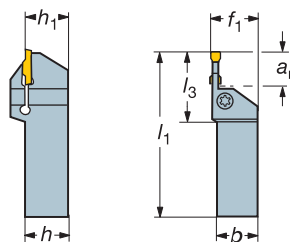
New Code
RF123T06-1010BM

Old Code
RF123T06-1010B

Shank tools

Screw clamp

R/LF123



Note!
When using CoroCut 2-edged insert, the a_r of the insert gives the maximum depth of cut.

Right hand style shown

Main application	a_r max ¹⁾	Seat size ²⁾	Ordering code	Dimensions, mm						Gauge inserts	Nm ³⁾
				b	f_1	h	h_1	l_1	l_3		
	13	H	R/LF123H13-2020BM	20	21	20	20	125	34	N123H2-0400- CM	4.5
	25	H	R/LF123H25-2020BM	20	21	20	20	125	47	N123H2-0400- CM	5.5
	13	J	R/LF123J13-2020BM	20	21	20	20	125	34	N123J2-0500- CM	4.5

¹⁾ a_r max. for holder. For max stability choose a holder with shortest possible a_r .

²⁾ To correspond with seat size on insert.

³⁾ Insert tightening torque Nm

Ordering example: 2 pieces RF123H13-2020BM

LF123H13-2020BM

R = Right hand, L = Left hand

Main spare parts

Seat size	Shank size	Screw	Key (Torx Plus)
J, H	2020	5512 044-01	5680 043-17 (30IP)

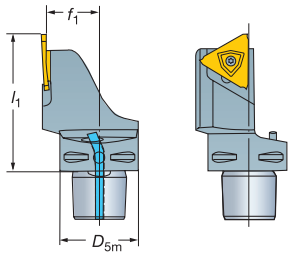
= New item

For a complete product assortment and further technical information, see Main Catalogue 2006 and Metalcutting Technical guide.

CoroCut® 3

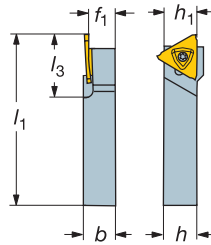
Coromant Capto® cutting units and shank tools
Screw clamp design

Cx-R/LF123



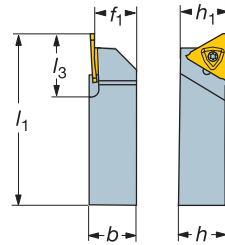
R/LF123

Shank size 1010 – 1616 mm



R/LF123

Shank size 2020 – 3232 mm



Right hand tool with right hand insert seat (T) shown.

Main application	α_r max	Seat size ¹⁾	Ordering code	Dimensions, mm			Gauge inserts	Nm ²⁾
				D_{sm}	f_1	l_1		
	6.4	T	C3-RF123T06-22045BM	32	22	45	N123T3-0150- CM	3
	6.4		C4-RF123T06-27060BM	40	27	60	N123T3-0150- CM	3
	6.4	U	C3-LF123U06-22045BM	32	22	45	N123U3-0150- CM	3
	6.4		C4-LF123U06-27060BM	40	27	60	N123U3-0150- CM	3

¹⁾ To correspond with seat size on insert.
²⁾ Insert tightening torque Nm

Ordering example: 2 pieces C3-RF123T06-22045BM
C3-LF123U06-22045BM
R = Right hand, L = Left hand

Main application	α_r max	Seat size ¹⁾	Ordering code	Dimensions, mm						Gauge inserts	Nm ²⁾
				b	f_1	h	h_1	l_1	l_3		
	6.4	T	RF123T06-1010BM	10	10	10	10	125	23	N123T3-0150- CM	3
	6.4		RF123T06-1212BM	12	12	12	12	125	23	N123T3-0150- CM	3
	6.4		RF123T06-1616BM	16	16	16	16	125	23	N123T3-0150- CM	3
	6.4		RF123T06-2020BM	20	20	20	20	125	23	N123T3-0150- CM	3
	6.4		RF123T06-2525BM	25	25	25	25	150	23	N123T3-0150- CM	3
	6.4		RF123T06-3232BM	32	32	32	32	170	23	N123T3-0150- CM	3
	6.4	U	LF123U06-1010BM	10	10	10	10	125	23	N123U3-0150- CM	3
	6.4		LF123U06-1212BM	12	12	12	12	125	23	N123U3-0150- CM	3
	6.4		LF123U06-1616BM	16	16	16	16	125	23	N123U3-0150- CM	3
	6.4		LF123U06-2020BM	20	20	20	20	125	23	N123U3-0150- CM	3
	6.4		LF123U06-2525BM	25	25	25	25	150	23	N123U3-0150- CM	3
	6.4		LF123U06-3232BM	32	32	32	32	170	23	N123U3-0150- CM	3

¹⁾ To correspond with seat size on insert.
²⁾ Insert tightening torque Nm

Ordering example: 2 pieces RF123T06-1010BM
LF123U06-1010BM
R = Right hand, L = Left hand

T = Right hand cutting insert, U = Left hand cutting insert.

Note!

When using CoroCut3 inserts, the α of the insert gives the maximum depth of cut.

Main spare parts

Cutting unit size	Shank size	Screw	Key (Torx Plus)	Screwdriver (Torx Plus) ¹⁾
C3-C4		5513 020-62	5680 049-02 (15IP)	5680 046-01 (8IP)
	1010	5513 020-63	5680 049-02 (15IP)	5680 046-01 (8IP)
	1212 - 3232	5513 020-62	5680 049-02 (15IP)	5680 046-01 (8IP)

¹⁾ Accessories, must be ordered separately

= New item

For a complete product assortment and further technical information, see Main Catalogue 2006 and Metalcutting Technical guide.

New additions to the CoroCut® family- to meet your requirements.

CoroCut 1- and 2-edge 0° customized blanks

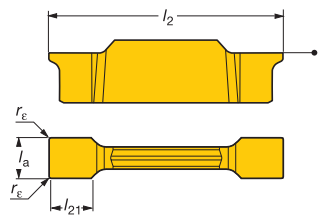
Use our blanks and grind your own specific profile.

Now available in extended range of widths:

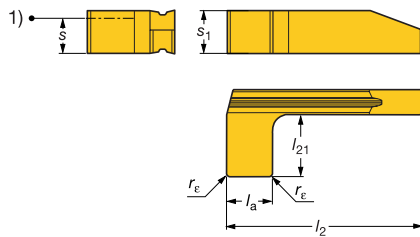
Range of widths after grinding 1.5-11.2 mm.

Blanks

0° blanks



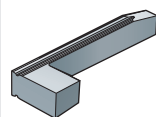
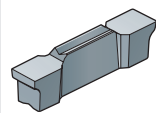
90° blanks

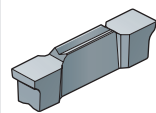
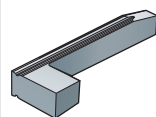
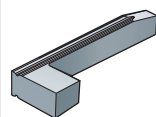


1) Cutting edge height

Dimension $l_a \times l_{21}$ is grinding area for specific profiles.

For grinding instructions see Metalcutting Technical guide




	Selection criteria, mm				Seat size ²⁾	Ordering code	Dimensions, mm					H10	H10F	H13A	
	l_a	Width range min	Width range max				l_2	l_{21} min	s	s_1	r_E				
	0°					CoroCut® 2-edge									
	2.3	1.5	1.9		D	N123D2-0230-0002-BG	15	2.8	-	-	0.2	☆	☆	☆	
	2.7	1.9	2.3		E	N123E2-0270-0002-BG	21.6	3.8	-	-	0.2	☆	☆	☆	
	3.8	2.3	3.4		F	N123F2-0380-0002-BG	21.6	4.0	-	-	0.2	☆	☆	☆	
	4.2	2.6	3.8		G	N123G2-0420-0002-BG	21.6	4.7	-	-	0.2	☆	☆	☆	
	5.2	3.2	4.8		H	N123H2-0520-0002-BG	26.2	6.0	-	-	0.2	☆	☆	☆	
	6.2	4.5	6.8		J	N123J2-0620-0002-BG	26.2	6.0	-	-	0.2	☆	☆	☆	
	7.2	5.5	6.8		K	N123K2-0720-0002-BG	26.2	6.0	-	-	0.2	☆	☆	☆	
	8.4	6.5	8.0		L	N123L2-0840-0002-BG	31.5	7.0	-	-	0.2	☆	☆	☆	
	CoroCut® 1-edge														
	11.60	8.0	11.2		L	N123L1-1160-0002-BG	30.5	7.8	-	-	0.2	☆	☆	☆	
	90°					CoroCut® 1-edge									
	6.0	-	5.9		H	R/LG123H1-0600-BG	25.65	8.0	4.35	5.5	0.2	☆	☆	☆	
	6.0	-	5.9		L	R/LG123L1-0600-BG	25.65	12.0	6.05	7.4	0.2	☆	☆	☆	

²⁾ To correspond with seat size on holder.

Ordering example: 10 pieces N123D2-0230-0002-BG H13A
 RG123H1-0600-BG H13A
 LG123H1-0600-BG H13A

N = Neutral, R = Right hand, L = Left hand

 = New item

For a complete product assortment and further technical information, see Main Catalogue 2006 and Metalcutting Technical guide.



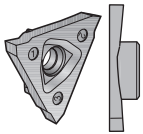
- Quick quotation
- Easy to order
- Competitive delivery

Even more possibilities thanks to tailored design!

If you do not find what you need in our comprehensive standard programme, choose the tool shape you require and we will tailor it for you to your dimensions.

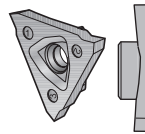
CoroCut® 3 inserts -Seat size T, U

123-T



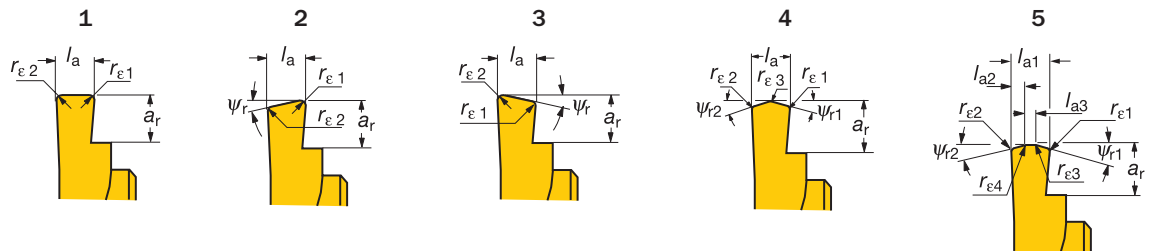
Right hand
Seat size (T)

123-U

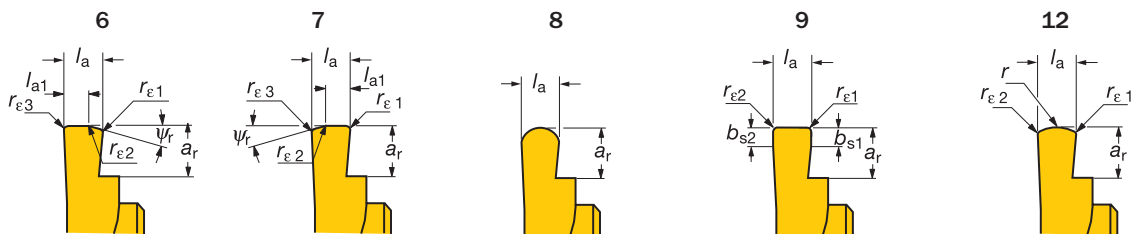


Left hand
Seat size (U)

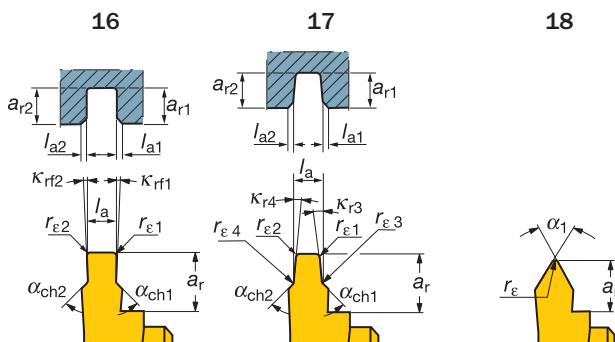
Shape options



Shape options



Shape options



Options shown as functional position in holder.

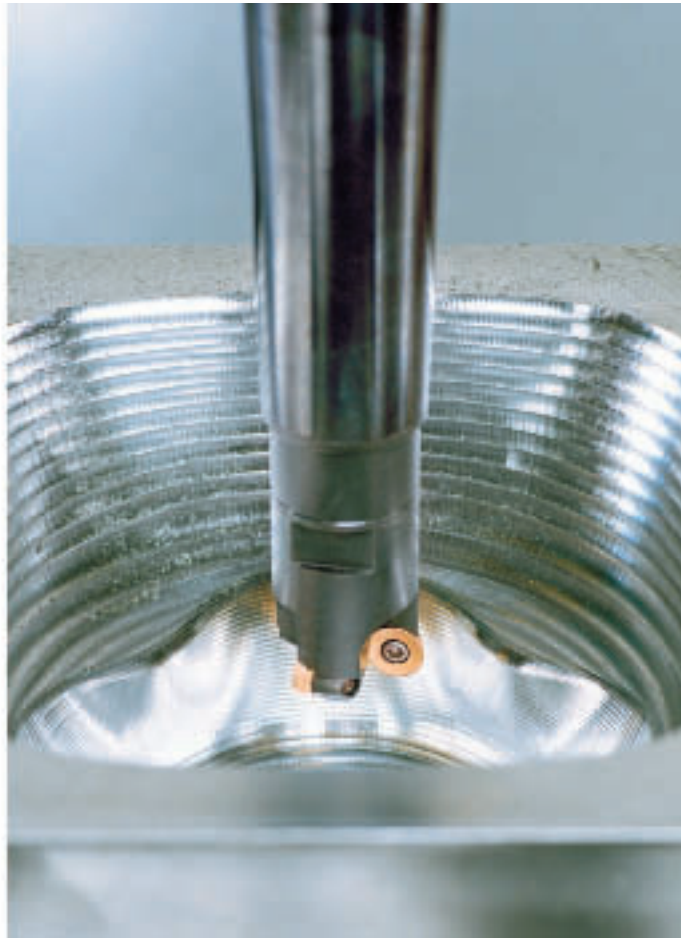
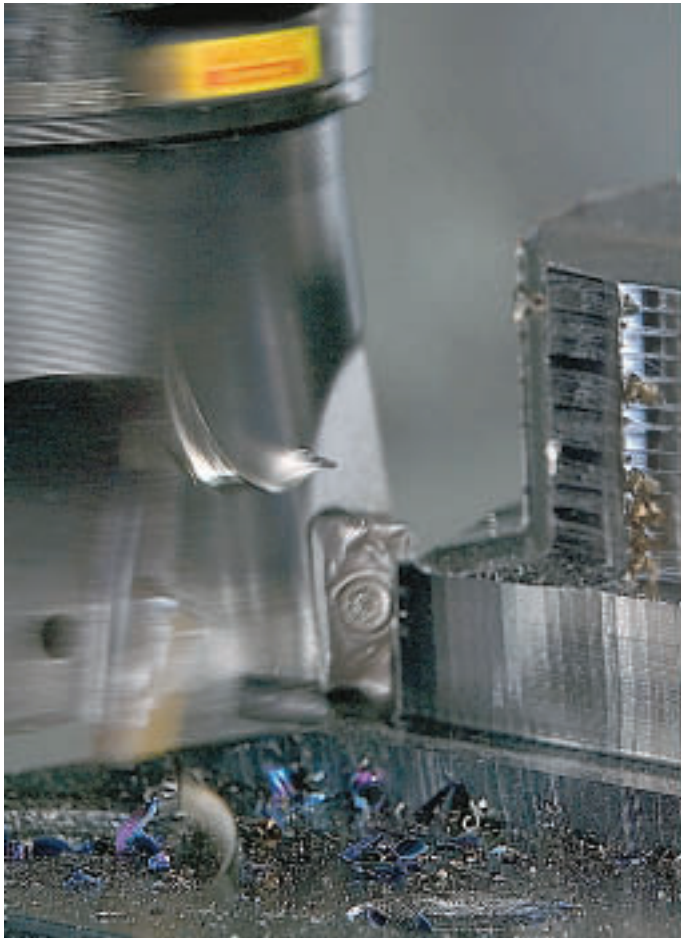
Right hand shown, seat size T

Options

Note! For specific details regarding the options, contact your Sandvik Coromant sales representative.

Seat size	T, U	ER-treatment	S=Small, M=Medium, 0=Zero or R=Recommended
No of edges	3 or 1	Insert width	l_a - 0.5-3.2 mm
Insert grades	GC4125, GC1020, GC1025, H10F	Tolerance on l_a	± 0.02 mm - ± 0.1 mm

No compromise for steel milling: a secure insert generation



Designed for modern machining

GC1030 and GC4240 will be the first in a new line of milling grades, presented in our new insert generation programme, introduced to provide an improved performance in the toughness demanding operations in steel milling. These two new grades have been especially optimized for shoulder milling, for example with CoroMill 390, but even give a reliable and secure performance in other tough milling operations.

These new grades are designed for modern machining where predictability and security are vital factors. By combining these new grades you can optimise your machining strategy according to your productivity needs.

GC4240

The first choice for milling with CoroMill 390, ideal for toughness demanding operations and where high metal removal rate is important.

GC1030

This grade is especially reliable for machining in unstable conditions for example when machining long overhangs and vibration is a problem. It is the perfect first choice for more delicate operations, those of smaller cutting diameters, where precision and accuracy count.

This introduction is the beginning of new advances in steel milling broadening your application areas and where improved material technologies mean significant cost savings and productivity increases for you.

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